



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D412-698-011**  
**Job Sheet 183224**



**Part No:** D412-698-011

**Job Qty:** 2 ea

**Part Name:** Cabin Door Roller LH Aluminum Door



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 9/13/18

**Job Tracking No:**

**Due Date:** 10/4/18

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3  
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 2 Ea  | 10/4/18    | 10/4/18  | 0.00      | 0.00    | Start Up Stores/Pkg-2 |           | OCT 11 2018 |
| 110   | Packaging          | 2 pcs | 10/4/18    | 10/4/18  | 0.00      | 0.00    | Packaging1-4          |           | OCT 11 2018 |
| 120   | QC                 | 2 pcs | 10/4/18    | 10/4/18  | 0.00      | 0.00    | QC4                   |           | OCT 11 2018 |
| 130   | Packaging          | 2 pcs | 10/4/18    | 10/4/18  | 0.00      | 0.00    | Packaging3-2          |           | OCT 11 2018 |
| 135   | DC                 | 2 pcs | 10/4/18    | 10/4/18  | 0.00      | 0.00    | DC                    |           | OCT 11 2018 |
| 140   | QC21-FG            | 2 Ea  | 10/4/18    | 10/4/18  | 0.00      | 0.00    | QC21                  |           | OCT 11 2018 |

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP D412-698-011 Location;FG034

135 - Photocopy bluefile and create labels per PPP D412-698-011 CHG003

140 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item | Component Name   | Quantity     | Operation             | Container |
|-------------|------------------|--------------|-----------------------|-----------|
| D3121-141   | Bracket Assembly | 6 Ea (3 ea)  | 90-Start up Operation | 510382182 |
| D3121-143   | Bracket Assembly | 2 Ea (1 ea)  | 90-Start up Operation | 5103728   |
| D3137-043   | Bracket Assembly | 2 Ea (1 ea)  | 90-Start up Operation | 5117179   |
| D3183-043   | Bracket Assembly | 2 Ea (1 ea)  | 90-Start up Operation | 5102311   |
| D3199-1     | Bracket          | 18 Ea (9 ea) | 90-Start up Operation | 5054065   |
| D3202-1     | Cover            | 2 Ea (1 ea)  | 90-Start up Operation | 5064851   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D3121-141      | 6        | 8         | 0         |
|                       | D3121-143      | 2        | 10        | 0         |
|                       | D3137-043      | 2        | 4         | 0         |
|                       | D3183-043      | 2        | 4         | 0         |
|                       | D3199-1        | 18       | 92        | 0         |
|                       | D3202-1        | 2        | 19        | 0         |

### Part Specifications

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Coord. <input type="checkbox"/><br/>             Rec/Store/Packaging <input type="checkbox"/><br/>             Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/><br/>             Quality <input type="checkbox"/><br/>             Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |  |                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                         |
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Specifications could not be found.

Plex 9/14/18 6:50 AM Dart.lajeunesse.marie



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |



**6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Qty<br>-027 | Qty<br>-028 | Part Number   | Description                      |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|----------------------------------|
| X           |             |             |             |             |             |             |             | D412-698-011  | CABIN DOOR ROLLER KIT, LH        |
|             | X           |             |             |             |             |             |             | D412-698-012  | CABIN DOOR ROLLER KIT, RH        |
|             |             | X           |             |             |             |             |             | D412-698-013  | DOOR HANDLE KIT                  |
|             |             |             | X           |             |             |             |             | D412-698-017  | REPLACEMENT DOOR TRACK KIT       |
|             |             |             |             | X           |             |             |             | D412-698-019  | BEARING OVERHAUL KIT             |
|             |             |             |             |             | X           |             |             | D412-698-021  | REPLACEMENT SHIM KIT             |
|             |             |             |             |             |             | X           |             | D412-689-027  | BRACKET KIT, LH (ALUMINUM DOORS) |
|             |             |             |             |             |             |             | X           | D412-689-028  | BRACKET KIT, RH (ALUMINUM DOORS) |
| 3           | 3           |             |             |             |             |             |             | D3121-141     | BRACKET ASSEMBLY                 |
| 1           |             |             |             |             |             |             |             | D3121-143     | BRACKET ASSEMBLY                 |
|             | 1           |             |             |             |             |             |             | D3121-144     | BRACKET ASSEMBLY                 |
| 1           | 1           |             |             |             |             |             |             | D3137-043     | BRACKET ASSEMBLY                 |
| 1           |             |             |             |             |             |             |             | D3183-043     | BRACKET ASSEMBLY                 |
|             | 1           |             |             |             |             |             |             | D3183-044     | BRACKET ASSEMBLY                 |
| 9           | 9           |             | 9           |             |             |             |             | D3199-1       | BRACKET                          |
|             |             |             |             |             |             | 1           |             | D3199-3       | FORWARD BRACKET, LH              |
|             |             |             |             |             |             |             | 1           | D3199-4       | FORWARD BRACKET, RH              |
| 1           | 1           |             | 1           |             |             |             |             | D3202-1       | COVER                            |
|             |             | 4           |             |             |             |             |             | D3203-1       | HANDLE                           |
|             |             | 1           |             |             |             |             |             | D3220-041     | DOUBLER                          |
|             |             | 1           |             |             |             |             |             | D3220-042     | DOUBLER                          |
|             |             | 2           |             |             |             |             |             | D3220-3       | DOUBLER                          |
|             |             |             |             | 7           |             |             |             | D3121-21      | BOLT                             |
|             |             |             |             | 5           |             |             |             | D3121-241     | BEARING ASSEMBLY                 |
|             |             |             |             | 1           |             |             |             | D3137-3       | GUIDE                            |
|             |             |             |             | 1           |             |             |             | D3137-5       | WASHER                           |
|             |             |             |             | 2           |             |             |             | D3183-045     | BEARING ASSEMBLY                 |
|             |             |             |             |             | 3           |             |             | D3238-1       | SHIM                             |
|             |             |             |             |             | 1           |             |             | D3238-3       | SHIM                             |
|             |             |             |             |             | 2           |             |             | D3238-5       | SHIM                             |
|             |             |             |             |             | 6           |             |             | D3238-11      | SHIM                             |
|             |             |             |             |             | 2           |             |             | D3238-13      | SHIM                             |
|             |             |             |             |             | 4           |             |             | D3238-15      | SHIM                             |
|             |             | 8           |             |             |             |             |             | NAS1149D0463J | WASHER (AN960JD416L)             |
|             |             | 8           |             |             |             |             |             | MS21042L4     | NUT (OR MS21042-4)               |
|             |             | 16          |             |             |             |             |             | MS24694-S98   | SCREW                            |
|             |             |             |             | 1           |             |             |             | MS24694-S101  | SCREW                            |